

Date: Wednesday, 10/10/2007 11:00:30 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER
Job Number	: 35065		
Estimate Number	: 10287		
P.O. Number	: <u>N/A</u>	Part Number	: D32021
This Issue	: 10/10/2007	S.O. No.	: <u>N/A</u>
Prsht Rev.	: NG	Drawing Number	: D3202 REV B1
First Issue	: <u>N/A</u>	Project Number	: N/A
Previous Run	: 33673	Drawing Revision	: B1
		Material	: <u>N/A</u>
Written By	:	Due Date	: 10/26/2007
Checked & Approved By	:	Qty:	<u>25</u> Um: Each
Comment	: Est Rev:B No Longuer Made In House 05-11-06 JLM		
	: Est Rev:C Now on Waterjet 07-04-18 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S032	5052-H32 .032 Sheet
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47.2294



Comment: Qty.: 1.6286 sf(s)/Unit Total : 32.5710 sf(s)

5052-H32 .032 Sheet

Batch: M105999

IB 07-10-22

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3202

Dwg Rev: B1

Prog Rev: B1

IB 07-10-22

(29)

2-Deburr if necessary

IB 07-10-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 07-10-22



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6 07/10/22 (29) counter

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 07/10/23 (29)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 27/10/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

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Drawing Name: COVER

Job Number: 35065

Part Number: D32021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m104846



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FL 07/10/23 (29)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CO 7/10/23

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51238A

(29X)

07/10/24 AS

LC

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(29)

Comment: FINAL INSPECTION/W/O RELEASE

Final 10/26

Job Completion



U 07/10/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

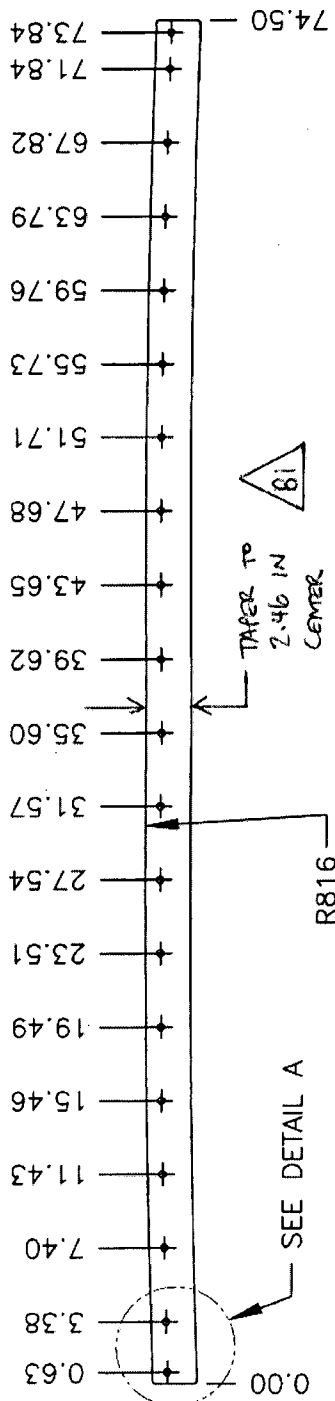
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



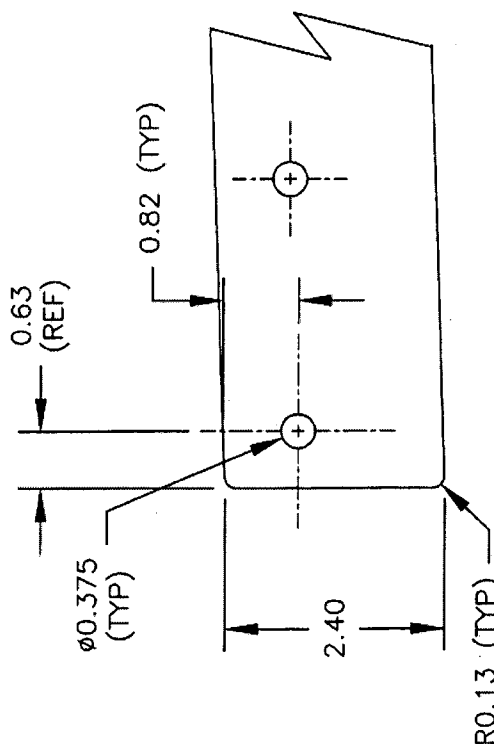
DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	SHEET 1 OF 1
				D3202	
DATE	03.10.16			TITLE	SCALE
				COVER	1:10
A	01.01.01	NEW ISSUE			
B	03.10.16	REDESIGN; PART NOW CURVED			
B1	<i>[Signature]</i> 04.05.14	CLARIFY MID-SPAN DIMENSION			



RELEASED

03.11.07 *[Signature]*

DETAIL A
SCALE 1:2



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
35065

D3202-1 COVER

- 1) MATERIAL: 5052-H32/H34 SHEET (QQ-A-250/8) 0.032 THICK (REF DART SPEC. M5052H32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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